

Page 1

Tuesday, Februa	ry 22, 2011	10:00:12 AM									
Item ID: Revision ID:	D3536-23			Accept				s	etup Sta	rt	
	Gasket							•	Sto	р	
Start Date: Required Date:	2/23/2011 3/9/2011	Start Qty: 20.00 Req'd Qty: 20.00		i	Cust Item Customer:						
Reference:								1 70	C4a		
Approvals:	Process Pla	in: MF	Date: -02-22	-Tooling:	<u>.</u> . <u></u> <u></u>	Date:		К	tun Sta	1 (001))51 1	3)13 (34)
	QC:		Date:	SPC (Y/N):		Date:			Sto	op	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3536	Rev	A									
		FLOW WATER JET		0.00				R	u- 9- 5	&	
Waterjet FLOW CNC Waterje	et	Memo 1-Cut as p Deburr if r	er Dwg D3536 . □Dwg Rev necessary	: A □Prog Rev:	A <u>C</u> 2-	•	٠				(5\$)
1 1 0 1 1 3 5 1 1 1 5 1 1 1 3 1 1 1 3 1 1 1 3 1		QC2- Inspect parts off	machine FAI/FAIB	0.00							
QC Quality Control		Memo		0.00				ls.	<u>, c - e -</u> 11	ð	
120	·	QC8- Inspect parts - se	cond check	0.00	1			(au			
QC Quality Control		Memo		_{0.00} S,ula	53 167			(475	ノ		

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W/O:			WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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				-	ĺ					
Part No	·	PAR #:	Fault Category:	NCR	: Yes	No DQ	4 :	Date: _	·	
	Resol	ution:	Disposition:	QA:	N/C C	losed:		Date: _	·	

NCR:	-		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B	Verification	Approval	A							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector						
								,						

Work Order ID 66560



Page 2

Tuesday, February 22, 2011 10:00:13 AM

Item ID:

D3536-23

Accept :

Setup Start

Stop



Revision ID:

Gasket Item Name:

Required Date: 3/9/2011

2/23/2011

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Start Run

QC:

SPC (Y/N): Date:

Date:

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty

Reject Number

Insp. Stamp

Qty

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

MK 11-03-02

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W/O:			WO	RK ORDER CHANGE	S			,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:								
	Res	olution:	Disposition);	QA: N/C Clo	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)		
		Description of NC		Corrective Action Section		Verification	Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector
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Picklist Print

Tuesday, February 22, 2011 10:00:10 AM

Work Order ID: 66560

Parent Item:

D3536-23

Parent Item Name: Gasket



Start Date: 2/23/2011

Required Date: 3/9/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	465.0000	1.3365	29.7	35,	١.	
										13211	3-78		

NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code	\sim
MAT	465		Q S
115916	65		
116832	400	116835	

Page 1

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W/O:			WO	RK ORDER CHANG	ES							
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			Fault Category: NC			NCR: Yes No DQA: Date:						
	Re	esolution:	Disposition	:	_ QA: N/C C	osed:		Date: _				
NCR:		\	WORK ORDER NON-CONFORMANCE (NCR)									
DATE	OTED	Description of NC			ion B	Verific	cation	Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Secti	on C	Chief Eng	QC Inspector			
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DART AEROSPACE LTD

Work Order: 6560

Description: Gasket

Part Number: D3536-23

Inspection Dwg: D3536 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	28.62	٠.		T BOI	
48.20	+/-0.030	48.36	بد		7	
44.70	+/-0.030	44.70	×		7	
39.31	+/-0.030	39.31	R		7	
33.92	+/-0.030	33.92	α		T	
28.53	+/-0.030	28.53	a		T .	
23.14	+/-0.030	23.14	Ox.		۲	
17.75	+/-0.030	(7.74	K.		T	
14.25	+/-0.030	14.74	2		T	
9.50	+/-0.030	9.50	7		ī	·
4.75	+/-0.030	4.71ธ	γ		7	
8.00	+/-0.030	8.00			τ	
16.00	+/-0.030	16.00	4		7	
24.00	+/-0.030	24.00	4		7	
32.00	+/-0.030	37.06	4		7	
39.00	+/-0.030	39 00	*		7	
48.00	+/-0.030	48,00	>		T BOZ	
0.30	+/-0.030	- 303	Sep.		٧	
0.30	+/-0.030	. 305	o		V	
1.89	+/-0.030	1.888	>		1	
Ø0.19	+0.005/-0.001	-190	Q		V	

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	86-6-11	Date: 1/1/03/02	Date:	N/A

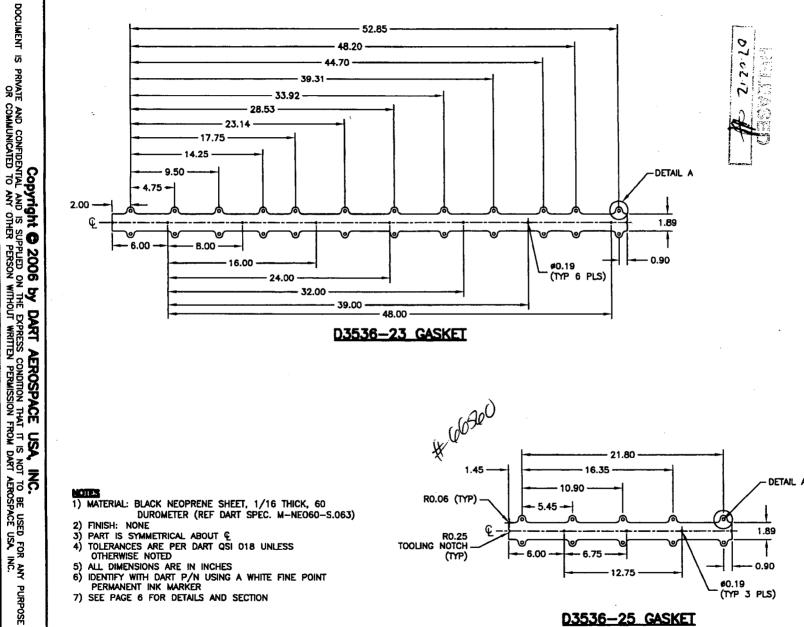
Rev	Date	Change	Revised,by	Approxed
A 07	7.03.14	New Issue	KJ/JLM	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\

W/O:			WORK ORDER CHANGES						
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
	7	olution: Disposition:							
NCR:		V	R NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Dat	& Sec	ication tion C	Approval Chief Eng	Approval QC Inspector
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^{*}H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



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1:10	GASKET		06.10.25	
SCALE	TIMLE.		DATE	
SHEET 3 OF 6	D3536	¥	#	
). REV. A	DRAWING NO.	APPROVED.	CHECKED	
PORT HADLOCK, WA		08	CB	
DART AEROSPACE USA. INC.	DAR	DRAWN BY	DESIGN	



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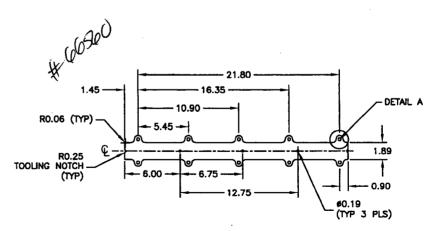
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DOCUMENT

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT €
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

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W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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			Fault Category: NC			NCR: Yes No DQA: Date:					
Resolution:			Disposition: QA: N/C Closed: Date:								
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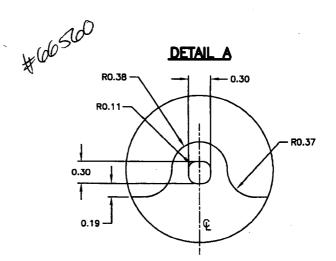
27.98 25.08 -18.50 -15.00 2.00 ---1.88 4.00 -#0.19 (TYP 2 PLS) DETAIL A

D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 THE TOLERANCE ARE THE INCLUSION AND THE INCLUSION
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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CHECKED	APPROVED //	DRAWING NO.	REV. A
FF FF	#	D3536	SHEET 6 OF 6
DATE		TIME	SCALE
06.10.25		GASKET	1:10

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DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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